

Work Order ID 74278

Tuesday, September 27, 2011 1:59:17 PM



Page 1

Item ID: D4306-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 9/27/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: mf

Date: 9-27 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4306	C

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube 50"
2- Bend tube with manuel pipe bender as per DT9567
*** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
3- Trim access tube material to finish size as per dwg D4306

PC 11-09-29 X2

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

S 40129

42

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4306-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Rib					
Start Date: 9/27/2011	Start Qty: 2.00		Cust Item ID:		
Required Date: 9/30/2011	Req'd Qty: 2.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
Packaging	Memo	0.00							
Packaging									
130 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

CP 11-09-29 **(2x)**

11/10/3
ME
11-09-29

W/O:			WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 74278

Parent Item: D4306-1

Parent Item Name: Rib



Start Date: 9/27/2011

Required Date: 9/30/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No			100	f	341.4518	4.1666	8.771789			
304 SQ Tube .75x.75x.049W													

8.7717

Location	Loc Qty	Loc Code
MAT018	267.0081839	
117775	98.2133	
118472	62.8252839	
118880	105.9696	8.7717
MAT034	1.8507	
117337	1.8507	
WA	72.59294	
118184	72.59294	

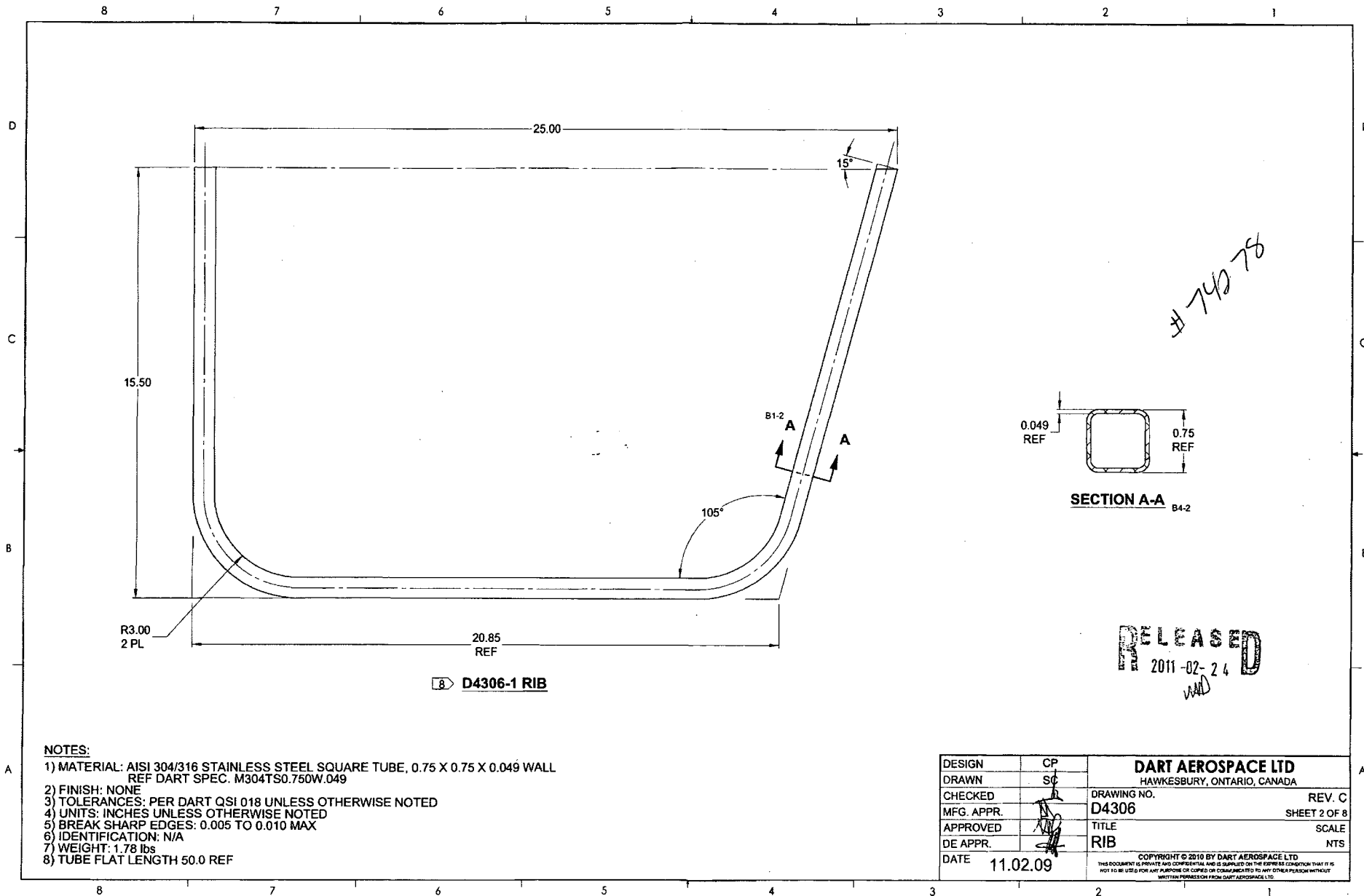
W/O:			WORK ORDER CHANGES					
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

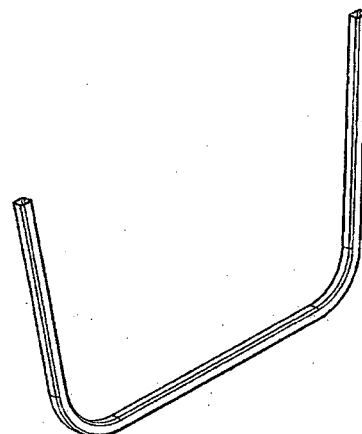
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

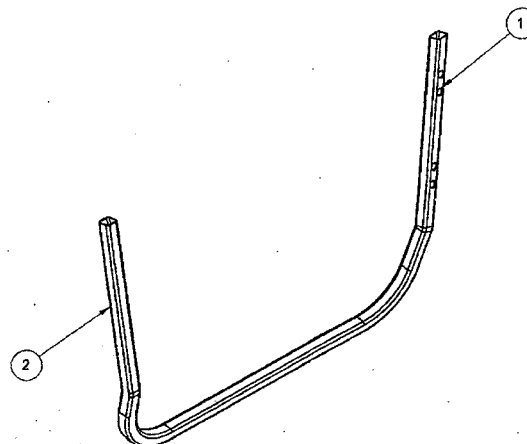
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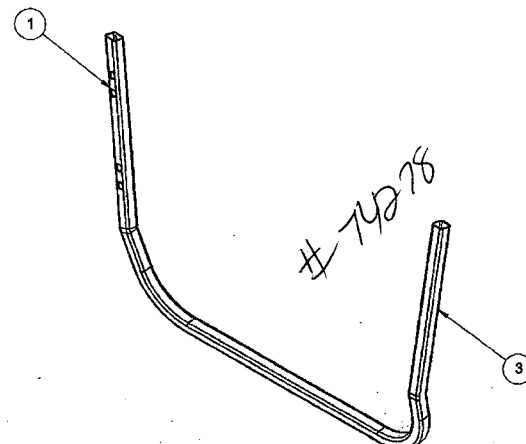
ITEM	QTY -043	QTY -044	QTY -045	P/N	DESCRIPTION
	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



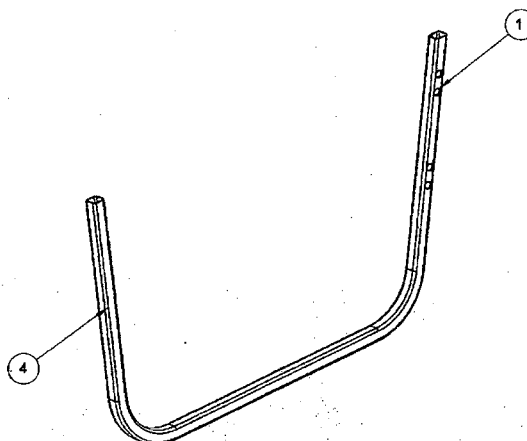
D4306-1 RIB



D4306-043 RIB ASSY, LH



D4306-044 RIB ASSY, RH



D4306-045 RIB ASSY

RELEASED
2011-03-18

REV.	DESCRIPTION	BY	DATE
C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-4-5); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.65" (C7-4, C8-4, C1-6, C2-6); CHANGED CUT ANGLE FROM 19° TO 22° (B6-4, B1-6); ADDED 4.50" REF DIM ON D4306-043044 (B6-3, B3-6)	SC	11.02.09
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4306	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		RIB	NTS
DATE	11.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD	

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